



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7702
Job Sheet 181403



Part No: 647.7702

Job Qty: 12 ea

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A2 IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier Lead Time	
90	Start up Operation	12 Ea	9/10/18	9/10/18	0.00	0.00	Start Up Large Fab-1	EL
120	Large Fab	12 pcs	9/10/18	9/10/18	0.00	4.94	Large Fab 4	EL
130	QC	12 pcs	9/10/18	9/10/18	0.00	0.00	QC9	CPC
140	QC	12 pcs	9/10/18	9/10/18	0.00	0.00	QC5	CPC
150	Outsource	12 pcs	9/10/18	9/10/18			GRO002-VC 7	CT 19-01-10
160	Packaging	12 pcs	9/10/18	9/10/18	0.00	0.00	Packaging2	JAN 16 2019
170	QC	12 pcs	9/10/18	9/10/18	0.00	0.00	QC5	38
180	SprayPaint	12 pcs	9/10/18	9/10/18	0.00	0.93	Spray Paint	AR 19-1-18 DAS
190	QC	12 pcs	9/10/18	9/10/18	0.00	0.00	QC14	JAN 28 2019 68
200	Packaging	12 pcs	9/10/18	9/10/18	0.00	0.00	Packaging3-1	CK 076 JAN 30 2019
210	QC21-SA	12 Ea	9/10/18	9/10/18	0.00	0.00	QC21	JAN 30 2019

Part Op 120 - 1- ASSEMBLE AND WELD AS PER DWG 0 ***IMPORTANT DIMENSION IS 11.60" ***

Descriptions: 150 - Issue P/O 040227 Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread

170 - INSPECT USING GO/NO GO GAUGE

180 - PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG PRIMER BATCH: 138981

210 - PLEASE NOTE ON PO: Apply only Class 3 Cad to the threaded are only CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.7711	Strut Tube	12 Ea (1 ea)	90-Start up Operation	5 127814
647.7712	Strut Tube	12 Ea (1 ea)	90-Start up Operation	5 132032
647.7713	Strut Thread	12 Ea (1 ea)	90-Start up Operation	5 127373



Container No: S143538



Part: 647.7702

Job No: 181403

Serial No/Batch: S143538

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Required	Inventory	Allocated
2	2	0
2	32	0
2	31	0

ns

Date: 01/10/19

Plex 7/26/18 8:16 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Specifications could not be found.

Plex 7/26/18 8:16 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042227



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042227
PO Date: 1/10/19
Due Date: 1/17/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181403	647.7702	Strut Assembly Issue P/O _____ Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread	Firmed	-	1/17/19	12 pcs	0 pcs	12 pcs	\$9.75/pcs	\$117.00
2	188313	647.7703	Strut Assembly Issue P/O _____ Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II ****NOTE: limite cad platting on thread to 0.003" or less****	Firmed	-	1/17/19	20 pcs	0 pcs	20 pcs	\$18.50/pcs	\$370.00
Grand Total:											\$487.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/11/19 8:58 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(015865-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

015865 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
15-Jan-2019		Aman			042227 /			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	647.7702 ✓ Rev.	647.7702 YELLOW CADMIUM IAW QQ-P-416F CLASS 1 TYPE II 0.0005" NOTE- CAD SHOULD NOT BE TOO THICK AROUND THREAD BAKE	CADMIUM CH	12	12	0	0	0
2	647.7703 ✓ Rev.	647.7703 01 -CAD YELLOW 0.0005 THICK CAD PLATE IAW QQ-P-416F CLASS I TYPEII CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD MATERIAL STEEL BAKE LIMITE ON THREAD 0.003 THICK OR LESS	CADMIUM CH	20	20	0	0	0

 DAS
 38
 9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.